

Date: Monday, 3/17/2008 12:00:07 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: DECK PLATE,FWD ,350 LITTER KIT
Job Number	: 38057		
Estimate Number	: 11104		
P.O. Number	:	Part Number	: D2364
This Issue	: 3/17/2008 S.O. No. :	Drawing Number	: D2364 REV.F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: F
Previous Run	: 31921	Material	:
Written By	:	Due Date	: 3/24/2008 Qty: 8 Um: Each
Checked & Approved By	: <u>JA 08 03 17</u>		
Comment	: EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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7.



Comment: Qty.: 0.6792 sf(s)/Unit Total : 5.4340 sf(s)  
 2024-T3 .063 Aluminum sheet  
 (M2024T3S063)  
 Batch: 106223 IB 08-3-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2364  
 Dwg Rev: F  
 Prog Rev: F

IB 8-3-14

(10)

2-Deburr if necessary IB 8-3-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-3-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/03/19 (16) counts

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

BR 08-03-25

(10)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/03/19	# 4.1	counter sink holes as per Drawing <del>D2364</del> D2364/Rev2 - Debur # All ready added 08/03/25	mf	08-03-25	10		08/03/19	
08/03/19	# 4.2	Inspect QC # 5 # All ready added 08/03/25	S	08/03/25	(x10)		08/03/19	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 12:00:07 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 38057

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M100700



10X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M. A

08/03/26

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JSJ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-26

X 10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57186

08/3/27

10

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



mf

08-03-27

10

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38057
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b> D2364
<b>Inspection Dwg:</b> D2364	<b>Rev:</b> F	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

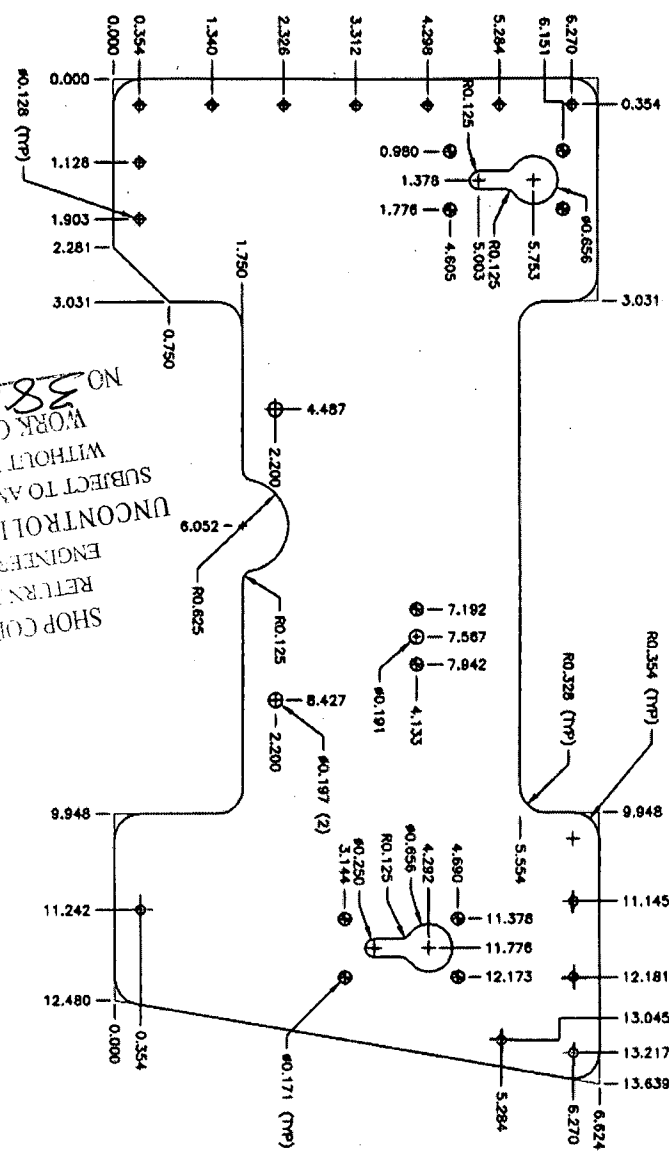
☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.628	*			
Ø0.171	+0.005/-0.000	.175	*			
0.354	+/-0.010	.354	*			
11.242	+/-0.010	11.242	*			
3.031	+/-0.010	3.025	*			
1.903	+/-0.010	1.903	*			
1.128	+/-0.010	1.128	*			
0.354	+/-0.010	.351	*			
1.340	+/-0.005	1.339	*			
2.326	+/-0.010	2.326	*			
3.312	+/-0.010	3.312	*			
4.298	+/-0.010	4.298	*			
5.284	+/-0.010	5.285	*			
6.151	+/-0.010	6.152	*			
6.270	+/-0.010	6.270	*			
0.354	+/-0.010	.354	*			
3.031	+/-0.010	3.030	*			
Ø0.656	+0.005/-0.000	.660	*			
5.003	+/-0.010	5.003	*			
4.605	+/-0.010	4.606	*			
1.776	+/-0.010	1.778	*			
0.980	+/-0.010	.981	*			
4.487	+/-0.010	4.488	*			
7.192	+/-0.010	7.194	*			
7.597	+/-0.010	7.597	*			
7.942	+/-0.010	7.943	*			
Ø0.191	+0.005/-0.000	.195	*			
Ø0.197	+0.005/-0.000	.201	*			
11.145	+/-0.010	11.145	*			
12.181	+/-0.010	12.181	*			
11.378	+/-0.010	11.378	*			
11.776	+/-0.010	11.776	*			
12.173	+/-0.010	12.173	*			
4.690	+/-0.010	4.691	*			
Ø 0.250	+0.005/-0.000	.255	*			
3.141	+/-0.010	3.143	*			
Ø 0.171	+0.005/-0.000	.176	*			

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-3-19	<b>Date:</b> 08/03/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	

COUNTER SINK HOLES:  
 ♦ C/SINK Ø0.225 x 100° (updated from 9 to 14 holes for DS 99.03.01 to correct CAD error)  
 ♦ C/SINK Ø0.308 x 100°



NO 38057  
 WORK ORDER  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK  
 FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REUSED  
 98/06/19 KE

DESIGN BY	KE	CHECKED	98.06.19	DATE
DRAWN BY	KE	APPROVED	98.06.19	DATE
DART AEROSPACE LTD				
HAWKESBURY, ONTARIO, CANADA				
REV. F				
SHEET 1 OF 1				
SCALE				
LITTER DECK PLATE, 350				
NEW ISSUE				
MOVED KEYWAY				
0.191 WAS 0.197				
GEOMETRY CHANGES				
0.063-0.071 THICK WAS 0.071 (TSR A371)				